

Date: Friday, 02/05/2008 2:56:45 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CROSSBOLT SPACER
Job Number	: 39022		
Estimate Number	: 13154		
P.O. Number	:	Part Number	: D36621
This Issue	: 02/05/2008 S.O. No. :	Drawing Number	: D3662 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 37189	Material	:
Written By	:	Due Date	: 09/05/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>JLP 08.5.02</u>		
Comment	: Est A 08.02.04 Now turned on Cobra EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T0625W049

6061-T6 Tube .625 x.049W



Comment: Qty.: 0.3255 f(s)/Unit Total : 6.5100 f(s)

6061-T6 Tube .6250 x.049W

Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4)

Batch M106015mmf 08/05/06/DJP

(21)

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA720

mmf 08/05/06/DJP

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 08/05/06/DJP

(21)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mmf 08/05/07

(21)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BarblyJS 08/05/09

21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 02/05/2008 2:56:46 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 39022

Part Number: D36621

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/12 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

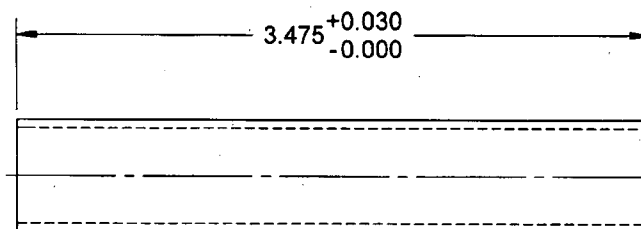
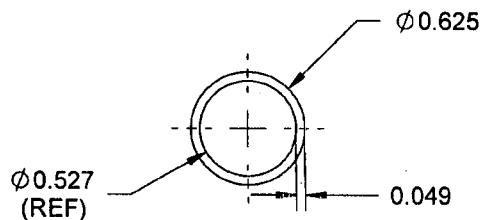
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

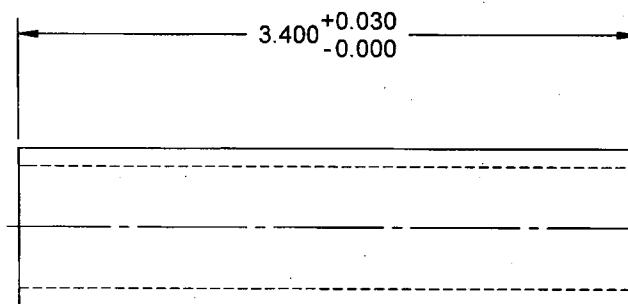
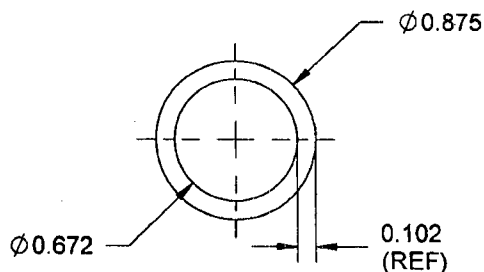
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39022



D3662-1 CROSS BOLT SPACER



D3662-3 CROSS BOLT SPACER

NOTES:

1) MATERIAL:

- D3662-1 - ALUMINUM 6061-T6/T62
TUBING PER VVV-T-700/6 OR AMS 4080/4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART MATERIAL SPEC. M6061T6T0.625W0.49)
- D3662-3 - ALUMINUM 6061-T6 (OR 6061-T651/T6510/T6511/T62)
ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART MATERIAL SPEC. M6061T6RX.XXX)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3662-1 - 0.03 LBS D3662-3 - 0.08 LBS

RELEASED
07.11.22

A	NEW ISSUE	PH	07.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	PA		
CHECKED	6	DRAWING NO.	REV. A
MFG. APPR.	EC	D3662	SHEET 1 OF 1
APPROVED	IM	TITLE	SCALE
DE APPR.	TH	CROSS BOLT SPACER	1:1
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

